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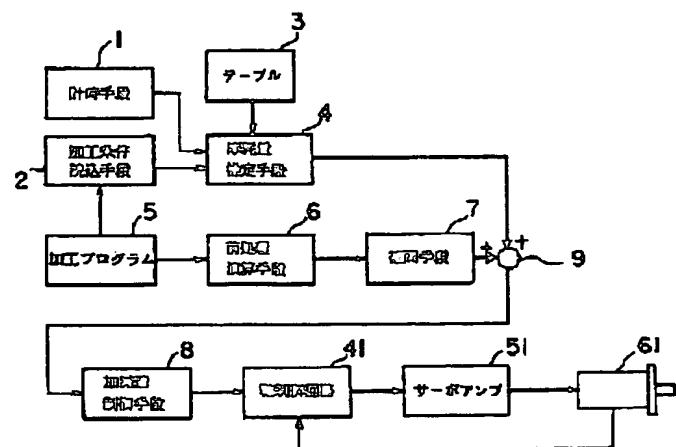
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TITLE : ABRASION CORRECTION METHOD



ABSTRACT : PURPOSE: To enable the offset amount of a tool due to abrasion to be corrected at all times.

CONSTITUTION: The used time of a tool is measured by a clock means 1, and the abrasion loss of the tool is estimated by an abrasion loss estimating means 4 at all times in response to measured time, so that the offset amount OSF_c of the tool after correction is obtained, and concurrently each correction command over distribution pulse is prepared with the offset amount OFS_c of the tool processed. The aforesaid correction process is executed even while the block of a process program 6 is being executed. A pre-process operating means 6 prepares a move command using read program data, it sends the command to an interpolation means 7, and interpolation is performed by the interpolation means 7, so that the distribution pulse is then outputted to a distribution correction means 9. The distribution correction means 9 then allows a correction command to be added to the distribution pulse from the interpolation means 7, so that the tool is controlled to be moved by means of the aforesaid corrected distribution pulse. By this constitution, even at the time of processing within the block of a processing program, the abrasion loss of the tool can be corrected at all times, so that a work can thereby be machined with high accuracy.

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